

Work Order ID 63944

Friday, November 19, 2010 1:35:18 PM



Page 1

Item ID:	D4055-11	Accept		Setup	Start	
Revision ID:						
Item Name:	Tank Front and Bottom				Stop	
Start Date:	11/22/2010	Start Qty:	1.00			
Required Date:	11/30/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	10-11-19	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4055	A								
100		0.00							
	Purchasing								
Purchasing	Memo	0.00							
	Issue P/O: 12965								
	Purchase part as per Dwg D4055								
	Possible Supplier: GFI								
	Material release note required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
	Packaging								
Packaging	Memo	0.00							
120	QC6- Inspect dimensions to drawing	0.00							
	QC								
Quality Control	Memo	0.00							

CZ 10/11/19 (2)

10/12/20 (2)

XZ
10/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 63944

Friday, November 19, 2010 1:35:18 PM

Page 2

Item ID:	D4055-11	Accept		Setup	Start	
Revision ID:						
Item Name:	Tank Front and Bottom				Stop	
Start Date:	11/22/2010	Start Qty:	1.00			
Required Date:	11/30/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	⇒ J	10/12/21		12	4		
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		10-12-21		2	4		
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		10-12-21		2	4		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63944

Friday, November 19, 2010 1:35:18 PM



Page 3

Item ID: D4055-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Front and Bottom

Start Date: 11/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/21
MS
10-12-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, November 19, 2010 1:35:18 PM

Page 1

Work Order ID: 63944



Parent Item: D4055-11



Parent Item Name: Tank Front and Bottom


Start Date: 11/22/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-11P  Tank Front and Bottom		Purchased	No			110	Each	0.0000	1	1		11/19/10	(2)

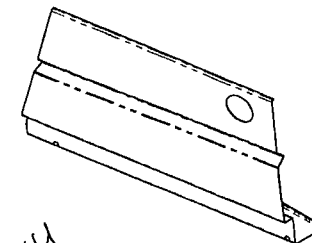
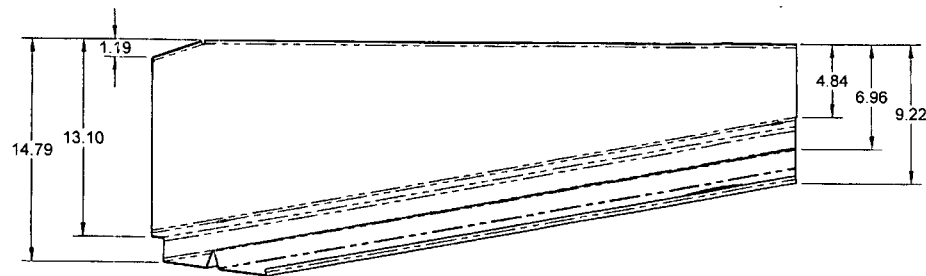
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

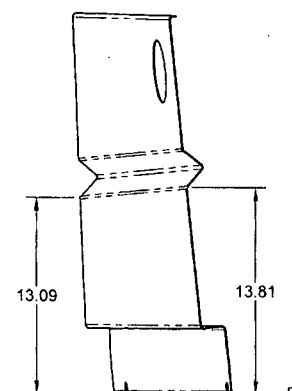
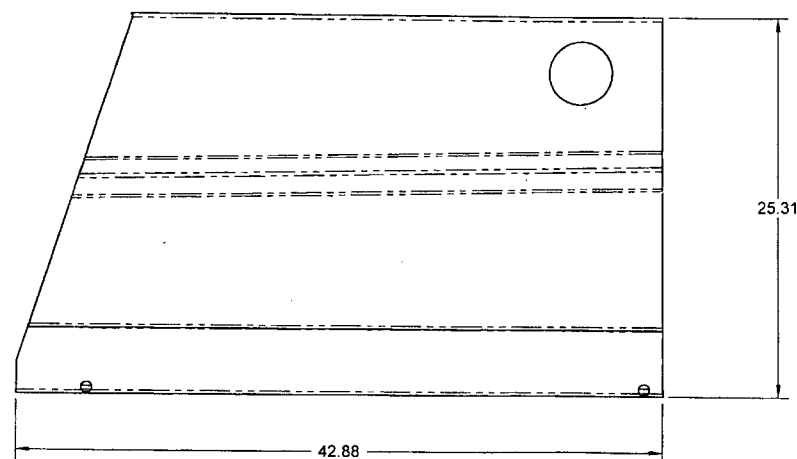
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#63944



D4055-11 TANK FRONT AND BOTTOM

RELEASED
2010-05-05
M4

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-11F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.29 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

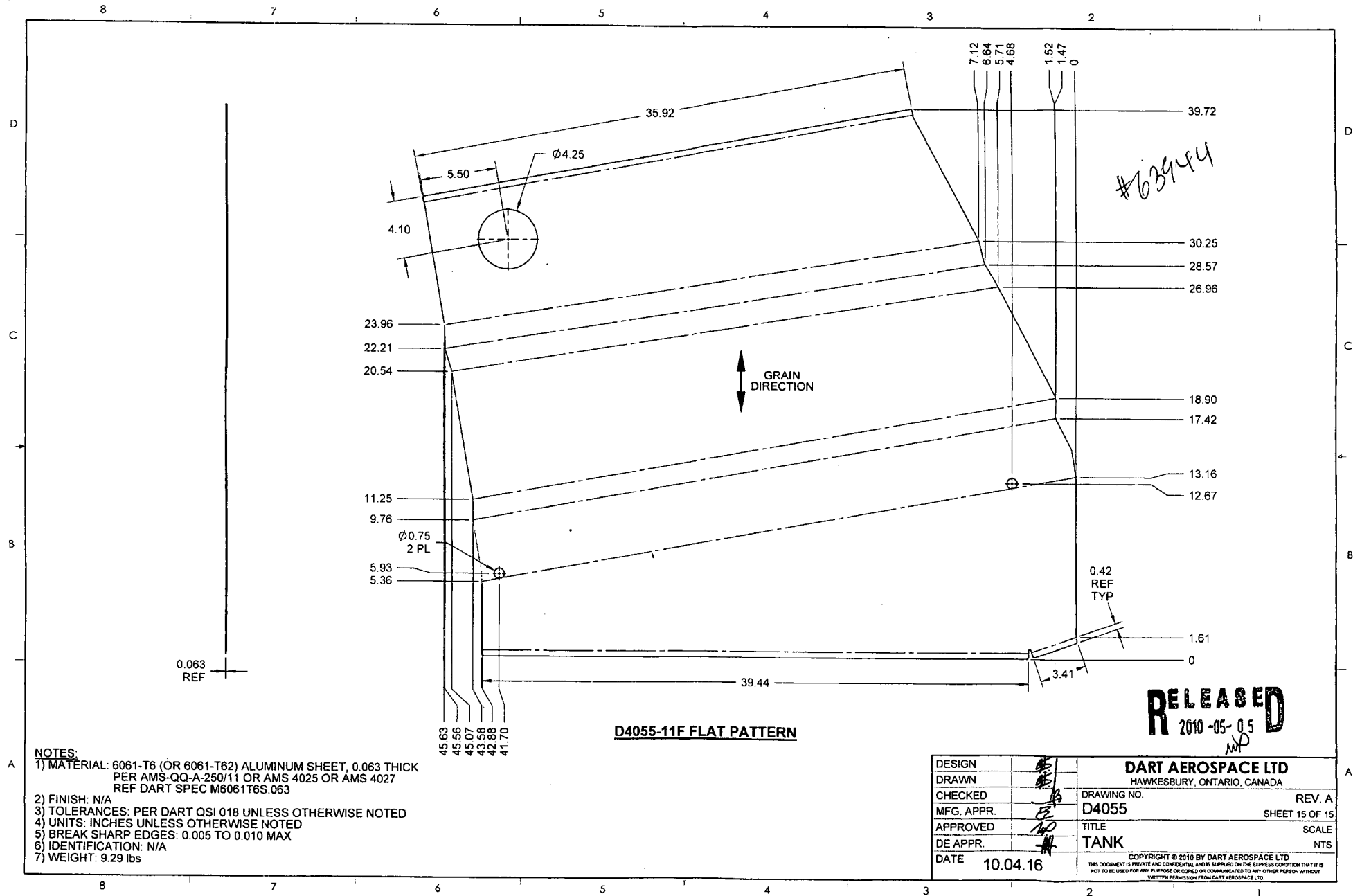
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO12965

Purchase Order Date 11/19/10

PO Print Date 11/23/10

Page Number 1 of 1

Order From :

VC-GFI001

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

FAXED
610/11/29

Contact Name

Vendor Phone 514 630 4877

Vendor Fax 514 630 4849

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
3	D4055-5P	Tank Upper Cut Out	12/13/10 - Yes	4.00 Each	Purolator ground	\$115.0000	\$460.00
		Special Inst:	MANUFACTURE AS PER DWG D4055 REV. A B63946				
5	D4055-9P	Tank Back	12/13/10 Yes	3.00 Each	Purolator ground	\$115.0000	\$345.00
		Special Inst:	AS ABOVE B63948				
6	D4055-11P	Tank Front and Bottom	12/13/10 Yes	✓ 2.00 Each	Purolator ground	\$115.0000	\$230.00
		Special Inst:	AS ABOVE B63944				

PO Total:

\$1,035.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 5

Change Date: 11/23/10

CL
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

Il est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON/SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO.	PAGE
JR	DY	MO - MO	AN - YR	
17	12	10	0452440	1/1



ENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO.	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA
DART GFI-0299	0223793	PO12965	

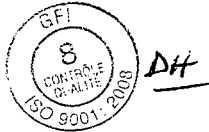
QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.	DESCRIPTION
---------------------	------------------------	-------------

2 D4055-11P

TANK FRONT AND BOTTOM

CERTIFICATE OF CONFORMANCE REQ

MFG. JOB# J0223793-001 QTY 2



EXPÉDITEUR / SHIPPER

N° DE BON DE LIVRAISON / SHIPPING MEMO NO.



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	<u>2</u>	OUR JOB NO	<u>J0223793</u>	SHIPPING MEMO	<u>0452440</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>-</u>	<u>2 PCS</u>	<u>PO12965</u>	<u>D4055-11P</u>	<u>A</u>	<u>TANK FRONT</u>	<u>A</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>AL 6061-T6</u> <u>(AMS-QQ-A250/11)</u>		<u>SAMUEL / ALCOA INC</u>		<u>371069</u> <u>8</u> <u>012/21</u>		
PROCESS			PROCESSOR	RELEASE NOTE #		
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>			<u>GFI</u>	<u>N/A</u>	
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0223793-001 (2 PCS)</u>					
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 17 DECEMBER 2010

G.F.I. Q.C. REP. Patricia Smith





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2008 + AS9100B

LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: DECEMBER 01,2010

Company Name: GFI Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe-Claire Qc
Zip Code: H9R 1A1

du client: 0077675
Customer's order #:

de commande SSMQ: 012204
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	2	.063" X 48" X 144"	6061 T6	AMS-QQ-A-250/11	371069

Bien à vous,
Yours truly,




8/10/12/21

LES MÉTAUX SPÉCIALISÉS SAMUEL, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5
SAMUEL SPECIALITY METALS, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5

TÉL: 514-457-3399
FAX: 514-457-9393

LET. DE COM 21/09/10

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that a sample representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Malcolm Murphy
Director of Manufacturing Davenport Works

Kenton P. Young
Quality Assurance Manager

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

1163116	0	Ship From:			RIVERDALE, IA.
Ship Date	B.L. No.	Invoice No.	Alcoa No.	Item	Page 1
2010-09-11	5158005	00000	1000221841-1		DCE-21841-1
P.O. No./Govt Contract No.	Customer	Alcoa Item			
C62699 Ln#: 1	SAMUEL SON & CO LT G041110647R05				

Ship To: SAMUEL SON & CO LTD
S.S.M.Q
21525 CLARKE-GRAHAM
BAIE D'URFE H9X 3T5 QC

Item Description
0.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-T6 PLAT SHEET FOR DISTRIBUTORS TOLERANCE
 GUARANTEED. AMS4027 REV N EXC MRK ASME-SB-209 REV 07 EXC_MRK ASTMB209 REV 07
 CMMPO25 REV S ((MARKED)) KRAFT PAPER
 INTERLEAVED MAX GROSS
 SKID WGT: 4500 LB QUAN TOL +/-30 %
 CQR 0222751 REV 04 CUST REQ 10-09-07 *** W/E 10-09-11 ***

[illegible]

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	239163	371069	1609	40	PC	27088 47004
2	239166	371069	4061	100	PC	27088 47004
3	239168	371069	4061	100	PC	27088 47004
			9731	240		

Notes for CQR: 0222751.4

PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISION DATED 1997-08-01.

CQR: 0222751.4 -Specification Limits -

UTS	TYS	EL4D
KSI	KSI	PCT
42.0	35.0	10

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	
	Min	0.40		0.15		0.8	0.04					REMAIN

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Per:

[Signature]

Malcolm Murphy
Director of Manufacturing Davenport Works

[Signature]

Kenton P. Young
Quality Assurance Manager

1163116	0			
Ship Date	B.L. No.	Invoice No.	Alcoa No. Item	Page 2
2010-09-11	5158005	00000	1000221841-1	DCE-21841-1
P.O. No./Govt Contract No.	Customer	Alcoa Item		
C62699 Ln#: 1	SAMUEL SON & CO LT G041110647R05			

CQR: 0222751.4 -Specification Limits (cont.)

Lot: 371069 - Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	UTS	TYS	EL4D
		Test	KSI	KSI	PCT
T6	Long Transv.	2	51.1 ✓	45.7 ✓	10.4 ✓
			50.8	45.3	10.3

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H9795095	Actuals		0.66 ✓	0.4 ✓	0.28 ✓	0.03 ✓	1.0 ✓	0.20 ✓	0.03 ✓

This material was melted in the United States or a Qualifying Country [REF DPARS 225.872.1(a)]; it was manufactured in the United States

